

Date: Monday, 2/27/2006 4:22:22 PM  
 User: Kim Johnston

## Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 26002 A		
Estimate Number	: 10008		
P.O. Number	: N/A	Part Number	: D2591
This Issue	: 2/27/2006 S.O. No. : N/A	Drawing Number	: D2591 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 25863	Material	: N/A
Written By	<i>See Comment Below</i>		
Checked & Approved By	<i>RJ OLE. 02.28</i>		
Comment	: Est Rev:I Removed from 9 Digit 05-10-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"	
		Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s) ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500) Batch: M19492 - 18	J.F. 06/03/02
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.700" long	J.F. 06/03/02 18
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA 039 and Dwg D2591  2-Deburr if required	J.F. 06/03/02 18
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/03/02 18
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.G. 06/03/02 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST51

*L 6/3/3 (18)*

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*(18) 06/03/06*

Job Completion



*U 06-03-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

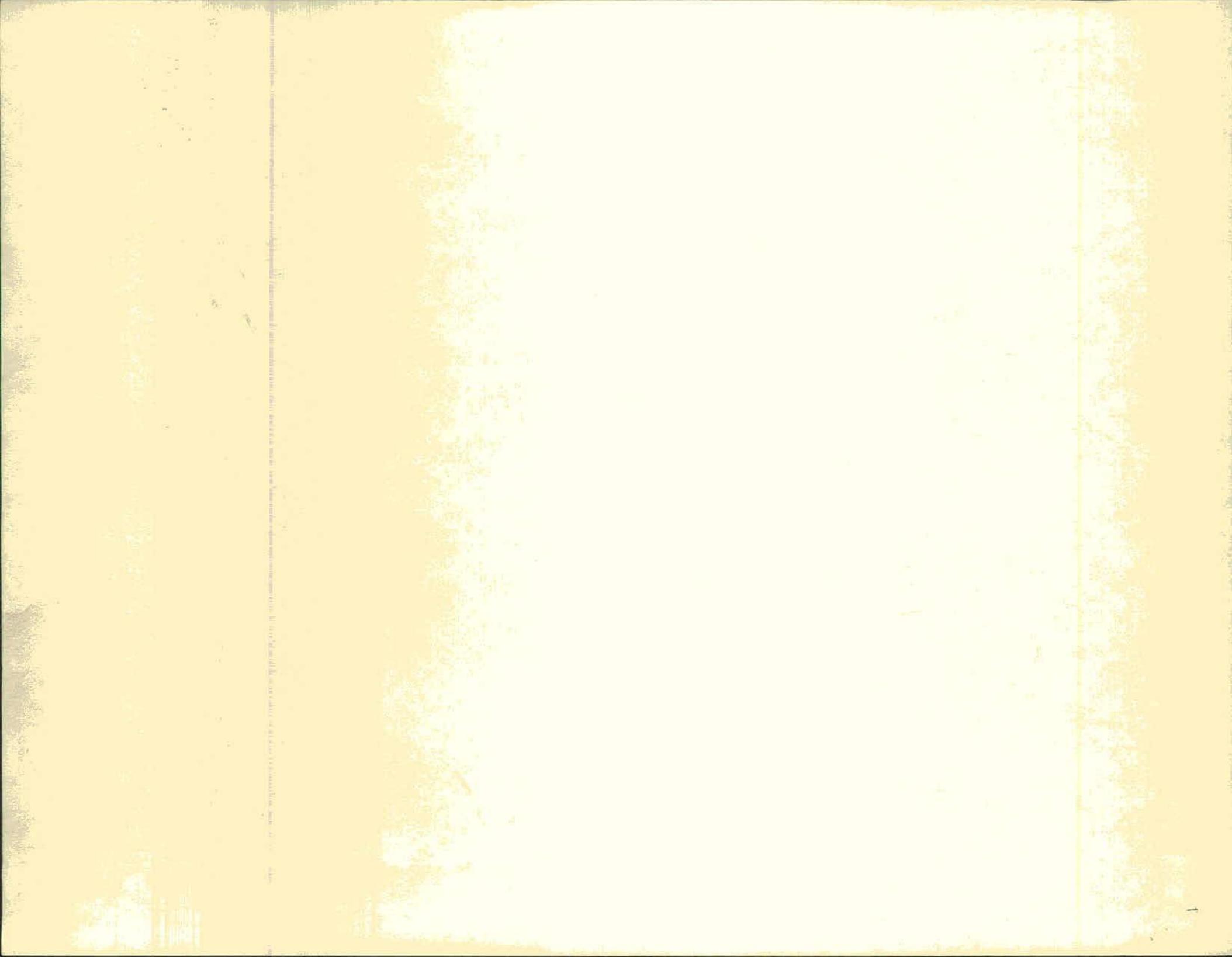
DART AEROSPACE LTD	Work Order:	26002
Description: GHW Lug	Part Number:	D2591
Inspection Dwg: D2591	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

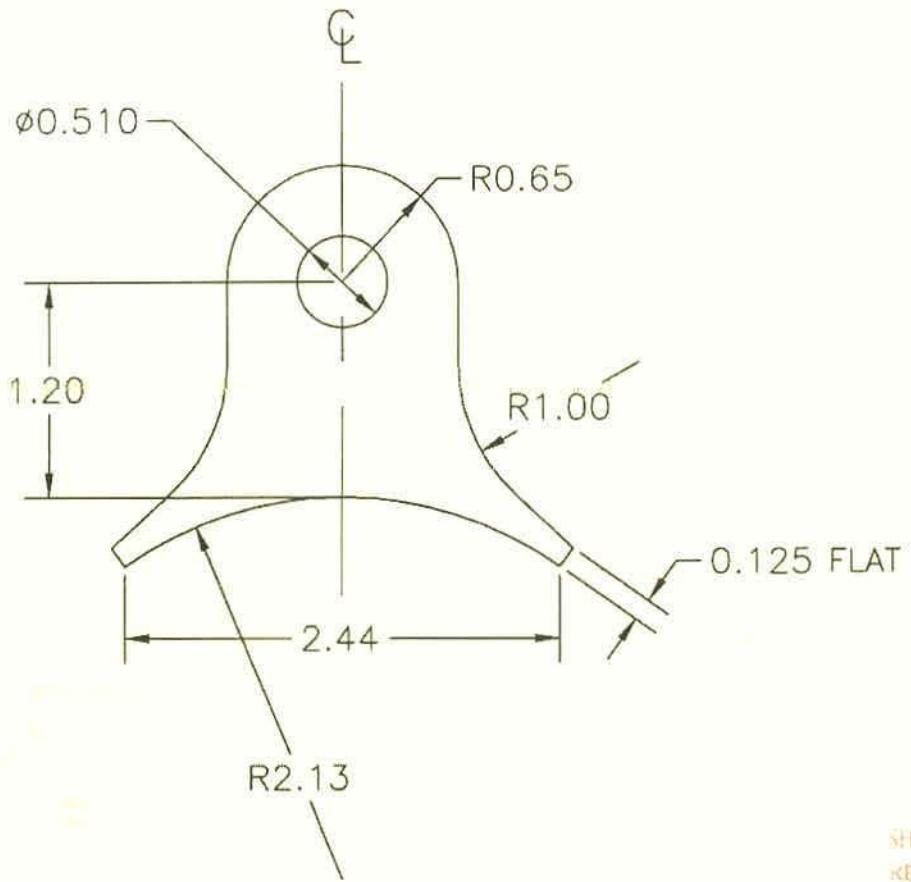
Measured by:	J.F.	Audited by:	S.G.	Prototype Approval:	N/A
Date:	06/03/02	Date:	06/03/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	P/O D205-641-011 & DS1 9161-011	KJ/JLM



**DART**

DESIGN <i>MWY</i>	DRAWN BY <i>MWY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

**RELEASED**  
 98.01.21 DS


BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: ASTM A36 STEEL 0.50 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 26002

